

Data		Intake valve	Exhaust valve
Valve retainer dia.		39.7—39.9	34.1—34.3
Valve stem dia.		9.92—9.94	
Valve length		131.5	
Code number on stem end		E 617 00	A 617 00 27
Filled-in sodium		without	with
Valve seat plating		valve seat nitride-hardened	
Height “h” of valve retainer	when new	2.54	2.49
	limit value	2.0	2.0
Adjusting angle for machining valves		30° + 15′	
Permissible runout at valve stem and valve seat max.		0.03	
Valve shaft wear (wear limit)		0.05	
Conventional tools			
Valve cone grinder or valve cone machining tool		e.g. made by Matra-Werke GmbH D-6000 Frankfurt/Main 8 e.g. made by Hunger, D-8000 München	

Note

Exhaust valves are filled with sodium.

When scrapping valves, pay attention to safety rules.
Do not melt valves filled with sodium, since there is
a risk of explosion, and do not use such valves for
making tools (punch, etc.), without first removing
filled-in sodium.

Be careful when removing sodium from valve, since sodium mixed with water and watery solutions reacts heavily explosive, while the resulting hydrogen gas may cause fires.

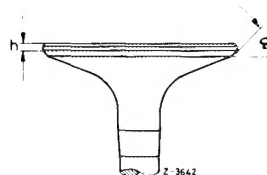
Sodium from cut-up or broken-up valves can be neutralized in a mixture comprising 2 liters of spirit of alcohol and 1 liter of water put into a vessel and placed in the open air.

Valves filled with sodium can be collected and shipped for neutralizing to: Garantieprüfstelle Werk Stuttgart-Untertürkheim.

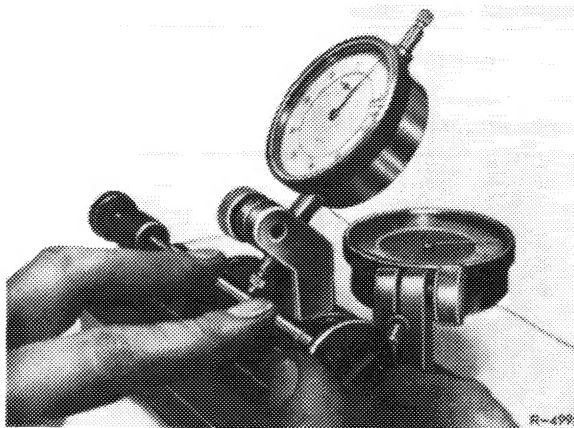
Checking and machining

1 Clean valves and check visually.

Valves with a burnt valve retainer, with insufficient height "h" of valve retainer and valves with worn out or scored valve stem should be replaced.



2 Measure runout on valve stem. If runout exceeds 0.03 mm, replace valve.



3 Machine valve seat.

Refer to operating instructions of machining tool and make sure of a 30° adjusting angle.

4 Measure runout on valve seat and height "h" of valve retainer.

As soon as the limit values are attained, replace valve.

